

Work Order ID 91215

October-03-12 2:38:00 PM

91215

Page 1

Item ID: D2661-I

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-03

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2661	Rev E

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program part number and batch number.

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA
DWG REV: E

Handwritten: 12/10/31 / FK 12/11/02

30

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Machine Keyway and inspect per attached dimension sheet

Handwritten: 12/10/31 / FK 12/11/02

30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00 ***30***

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00 ***30***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>12/10/12</i> <i>FK</i> <i>12/11/02</i>		<i>30</i>			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>R</i> <i>12-11-03</i>		<i>30</i>			<i>(DAS 04 9-03)</i>
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>30</i> <i>4</i> <i>12/11/05</i>					

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Page 3

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Revision ID:

Stop ***NS2***

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Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Packaging

Memo

0.00

30 X 4 *mf*
12/11/07

30 ϕ 10-11.8

8 12/11/07

ml 22878

8:30
START TIME: *3200 F* FINISH TIME: *9:00*
OVEN TEMPERATURE:

432

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 91215

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Page 4

Item ID: D2661-1

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Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/8
MLJ 12-11-08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

October-03-12 2:38:04 PM

Page 1

91215

D2661-1

Required Date: 12/11/2012

Required Qty: 30.00

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

D6101-003

[illegible]

30

F.K 12/10/27

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
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FAULT CATEGORY											
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DART AEROSPACE LTD		Work Order:	91215
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.128	.128	.128	.126	.126
H	0.210	0.230		.220	.225	.225	.225	.225
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.322	1.325	1.326	1.325	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.1365	1.137	1.135	1.135
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.129	.129	.129	.129	.129
Q	0.240	0.260		.246	.250	.250	.250	.251
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.123	.123	.123	.123	.123
T	1.565	1.585		1.578	1.577	1.578	1.5755	1.576
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.921	.922	.922
W	0.787	0.807		.797	.797	.798	.797	.799
X	5.990	6.010		6.000	6.001	6.001	6.001	6.002
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.498	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.003	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.503	.504	.504	.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.236	.236	.237	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.113	.112	.112	.113	.112
Accept/Reject				✓	✓	✓	✓	✓

Measured by: F.K.	Date: 12/10/28
Audited by: RP	Date: 12.11.03
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD		Work Order:	91215
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
A	3.611	3.621		3.616	3.615	3.615	3.615	3.615
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.4985	2.500	2.500	2.500
E	1.674	1.684		1.679	1.678	1.679	1.680	1.680
F	1.357	1.367		1.362	1.361	1.363	1.363	1.361
G	0.100	0.140		.125	.121	.123	.123	.122
H	0.210	0.230		.224	.220	.220	.222	.221
I	0.615	0.685		.685	.680	.680	.680	.680
J	2.470	2.510		2.491	2.490	2.491	2.491	2.491
K	1.313	1.343		1.323	1.321	1.321	1.323	1.322
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.134	1.133	1.1345	1.1326	1.1338
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.130	.128	.127	.128	.124
Q	0.240	0.260		.251	.250	.250	.250	.252
R	0.677	0.697		.687	.690	.687	.685	.687
S	0.100	0.140		.123	.120	.119	.122	.120
T	1.565	1.585		1.5745	1.574	1.575	1.573	1.5737
U	0.540	0.560		.550	.546	.545	.546	.548
V	0.912	0.932		.923	.920	.919	.919	.921
W	0.787	0.807		.799	.798	.799	.798	.798
X	5.990	6.010		6.001	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.497	.496	.497
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.504	.506	.504	.504	.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.237	.237	.237	.237
AG	0.510	0.515		.512	.510	.510	.510	.510
AH	0.100	0.120		.112	.113	.113	.113	.113
Accept/Reject								

Measured by: F.K. / 12/10/30	Date: 12/10/29
Audited by: [Signature]	Date: 12.11.03
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ [Signature]	[Signature]

DART AEROSPACE LTD		Work Order:	91215
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	3.611	3.621		3.612	3.613	3.614	3.614	3.612
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.678	1.679	1.679	1.680	1.679
F	1.357	1.367		1.361	1.361	1.361	1.361	1.361
G	0.100	0.140		.127	.122	.120	.118	.118
H	0.210	0.230		.223	.220	.217	.216	.216
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.322	1.320	1.320	1.320
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.139	1.134	1.134	1.1316	1.131
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.127	.122	.121	.122	.123
Q	0.240	0.260		.248	.247	.248	.250	.250
R	0.677	0.697		.687	.686	.685	.685	.689
S	0.100	0.140		.119	.119	.118	.119	.119
T	1.565	1.585		1.577	1.575	1.5714	1.571	1.571
U	0.540	0.560		.550	.550	.549	.549	.549
V	0.912	0.932		.919	.919	.9175	.920	.922
W	0.787	0.807		.799	.801	.801	.800	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.497	.492	.494	.498	.501
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.502	.504	.505	.504	.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.510	.510	.510	.510	.510
AH	0.100	0.120		.113	.113	.113	.113	.113

Accept/Reject

Measured by:	<i>HA</i>	Date:	12/10/30
Audited by:	<i>RD</i>	Date:	12-11-3
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>HA</i>

1	2	3	4	5
10	20	30	40	50
60	70	80	90	100
110	120	130	140	150
160	170	180	190	200
210	220	230	240	250
260	270	280	290	300
310	320	330	340	350
360	370	380	390	400
410	420	430	440	450
460	470	480	490	500
510	520	530	540	550
560	570	580	590	600
610	620	630	640	650
660	670	680	690	700
710	720	730	740	750
760	770	780	790	800
810	820	830	840	850
860	870	880	890	900
910	920	930	940	950
960	970	980	990	1000

DART AEROSPACE LTD		Work Order:	91215
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16 1	17 2	18 3	19 4	20 5
A	3.611	3.621		3.613	3.613	3.612	3.613	3.612
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.678	1.678	1.678	1.678	1.678
F	1.357	1.367		1.360	1.361	1.360	1.362	1.360
G	0.100	0.140		.120	.119	.120	.123	.122
H	0.210	0.230		.2175	.218	.219	.220	.218
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.4915	2.490	2.490	2.490	2.490
K	1.313	1.343		1.321	1.320	1.322	1.322	1.3215
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1314	1.130	1.132	1.135	1.1326
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.125	.127	.126	.125	.125
Q	0.240	0.260		.251	.251	.251	.248	.249
R	0.677	0.697		.691	.689	.686	.685	.685
S	0.100	0.140		.119	.120	.120	.117	.118
T	1.565	1.585		1.5712	1.570	1.572	1.575	1.5726
U	0.540	0.560		.5495	.549	.549	.551	.551
V	0.912	0.932		.9205	.921	.920	.922	.919
W	0.787	0.807		.798	.7975	.799	.799	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.501	.502	.500	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.5045	.505	.504	.504	.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.510	.510	.510	.512	.512
AH	0.100	0.120		.113	.113	.113	.113	.113

Accept/Reject

Measured by:	<i>[Signature]</i>	Date:	12/10/31
Audited by:	<i>[Signature]</i>	Date:	12-11-3
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	91215
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661	Rev: E	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	3.611	3.621		3.6135	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.677	1.679	1.679	1.679	1.679
F	1.357	1.367		1.360	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.122	.120	.120	.120
H	0.210	0.230		.218	.220	.220	.219	.219
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.3215	1.322	1.321	1.321	1.322
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1327	1.1336	1.132	1.133	1.132
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.128	.130	.130	.130	.131
Q	0.240	0.260		.250	.250	.251	.250	.251
R	0.677	0.697		.685	.687	.687	.687	.687
S	0.100	0.140		.120	.119	.120	.117	.120
T	1.565	1.585		1.5727	1.5736	1.5725	1.574	1.573
U	0.540	0.560		.550	.551	.550	.551	.551
V	0.912	0.932		.921	.924	.923	.923	.924
W	0.787	0.807		.799	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.498	.500	.500	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.5045	.505	.505	.505	.505
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.113	.113	.113	.113	.113
Accept/Reject								

Measured by:	<i>[Signature]</i> 15K 12/11/01 12/11/01	Date:	12/10/31
Audited by:	<i>[Signature]</i>	Date:	12.11.3
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 91215	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

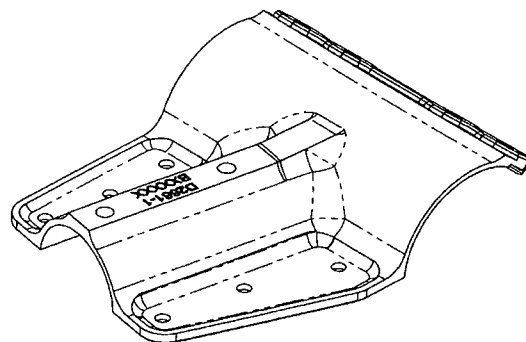
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26	27	28	29	30
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.125	.123	.124	.123	.123
H	0.210	0.230		.221	.220	.221	.220	.220
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.324	1.323	1.324		
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1365	1.1345	1.135	1.134	1.1325
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.130	.130	.131	.130	.130
Q	0.240	0.260		.250	.251	.251	.251	.251
R	0.677	0.697		.687	.687	.687	.688	.688
S	0.100	0.140		.121	.121	.119	.120	.121
T	1.565	1.585		1.5775	1.575	1.576	1.574	1.5735
U	0.540	0.560		.551	.550	.550	.551	.550
V	0.912	0.932		.924	.924	.924	.924	.924
W	0.787	0.807		.795	.796	.797	.796	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.499	.498	.498	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.505	.505	.505	.505	.505
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.113	.113	.113	.113	.113
Accept/Reject								

Measured by: F.k.	Date: 12/11/01
Audited by: RD	Date: 12.11.01
Prototype Approval:	Date:

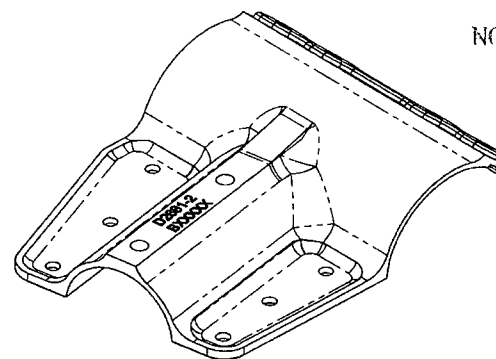
Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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WITHOUT NOTICE

WORK ORDER
NO. 91215 MJS
12-10-03



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2, B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC.
KENT, WA

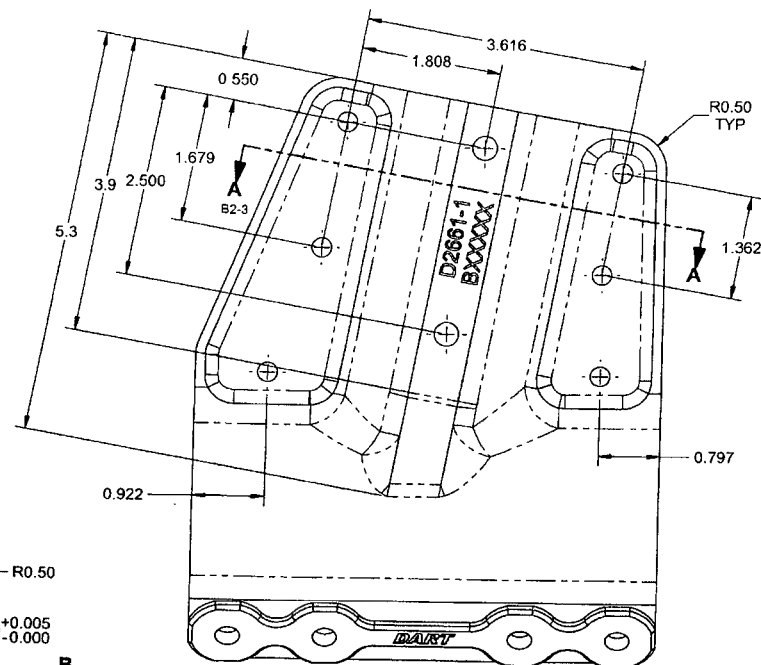
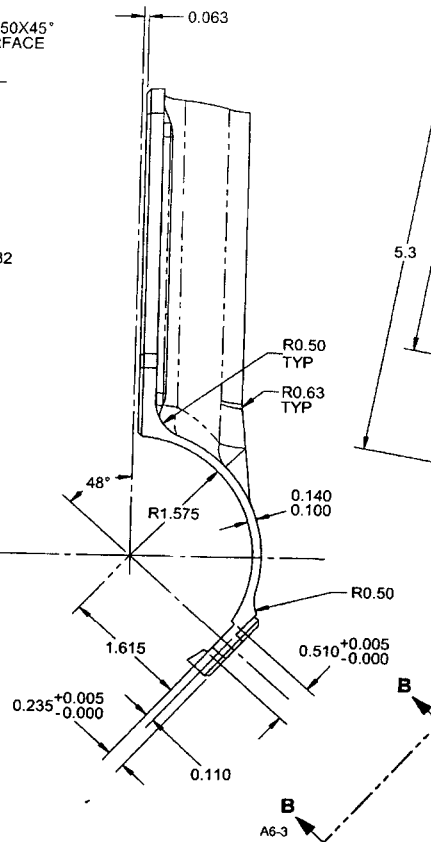
DRAWING NO. **D2661** REV. E
SHEET 1 OF 5
TITLE **SADDLE, OUTSIDE** SCALE NTS

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Technical drawing of a mechanical part, likely a bracket or plate, showing dimensions and features.

Dimensions and Features:

- Overall width: 4.642
- Overall height: 4.632
- Slanted section height: 3.826
- Bottom flange height: 1.571 REF
- Bottom flange width: 2.727
- Chamfer: 0.050x45° AROUND SURFACE 2 PL
- Holes:
 - Three in the slanted section: two $\varnothing 0.257$ 6 PL, one $\varnothing 0.316$ 2 PL
 - Three in the bottom flange
- Angle: 60° (indicated at the bottom right corner of the slanted section)

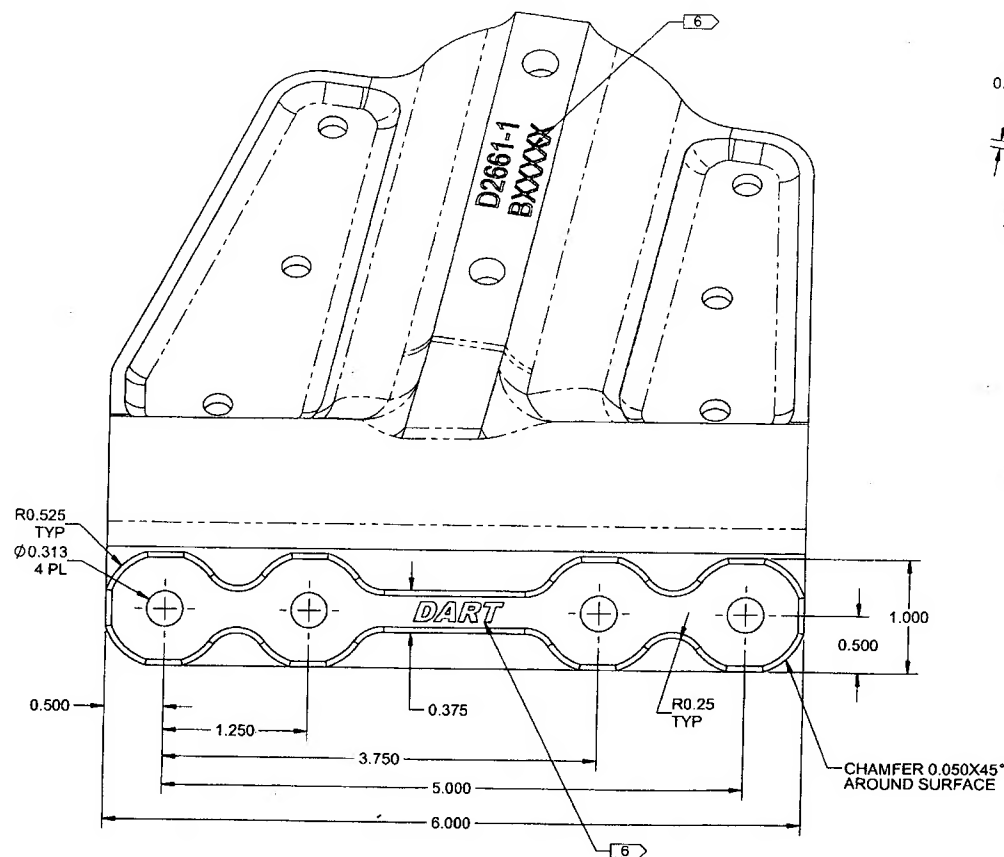


1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
2) FINISH: MAKE FROM D6101-003 SADDLE BILLET
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART PN AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

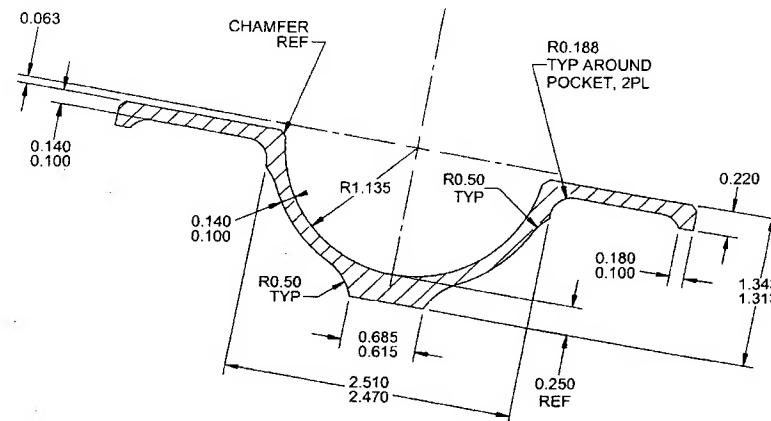
RELEASED
2011-11-16

DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2661 TITLE SADDLE, OUTSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	REV. I
DRAWN	<i>g</i>		SHEET 2 OF 2
CHECKED	<i>ASS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

91215



VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED

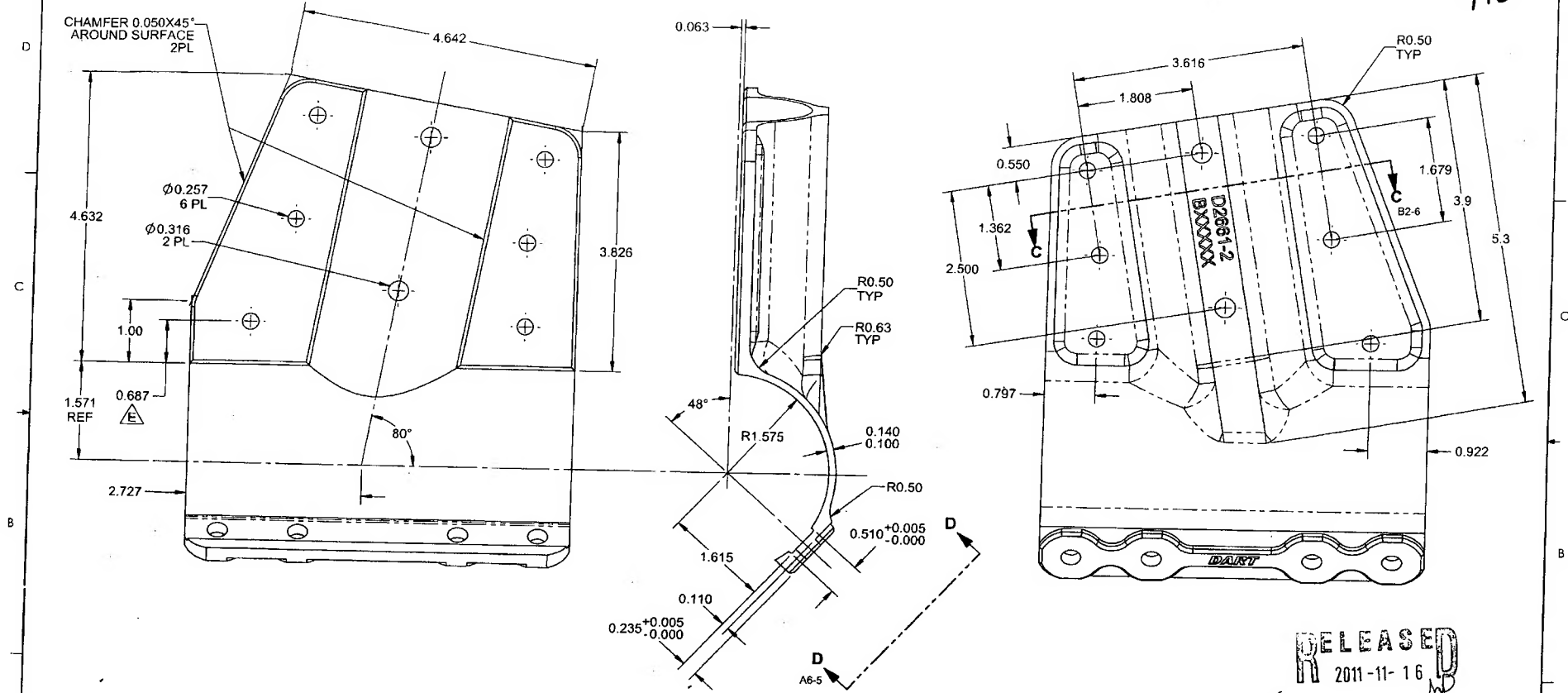


VIEW A-A
SCALE 1.5X C3-2

RELEASED
R 2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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91215



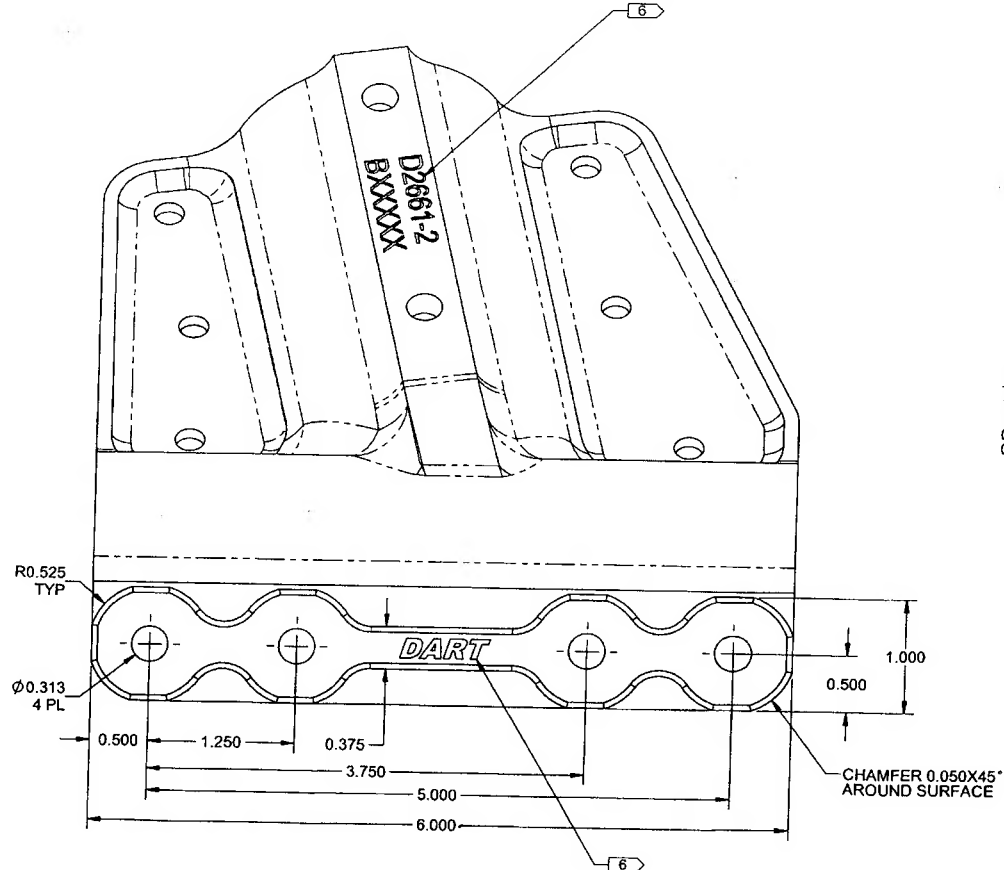
RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

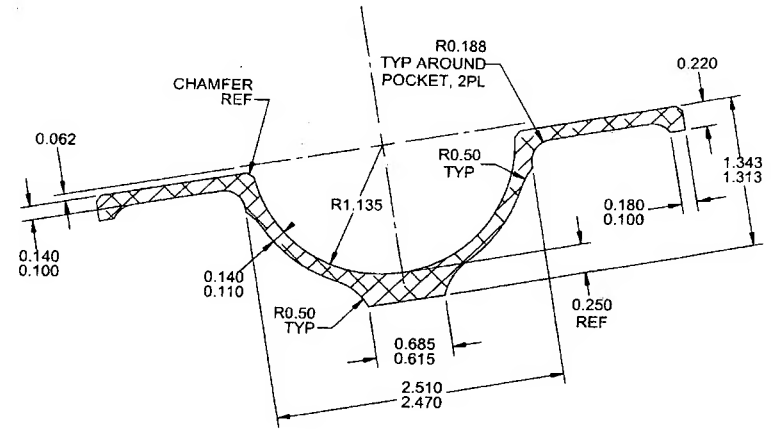
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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91215



VIEW D-D 84-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16
ANT

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	ASS	D2661	SHEET 5 OF 5
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DE APPR.	WAP	SADDLE, OUTSIDE	NTS
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